



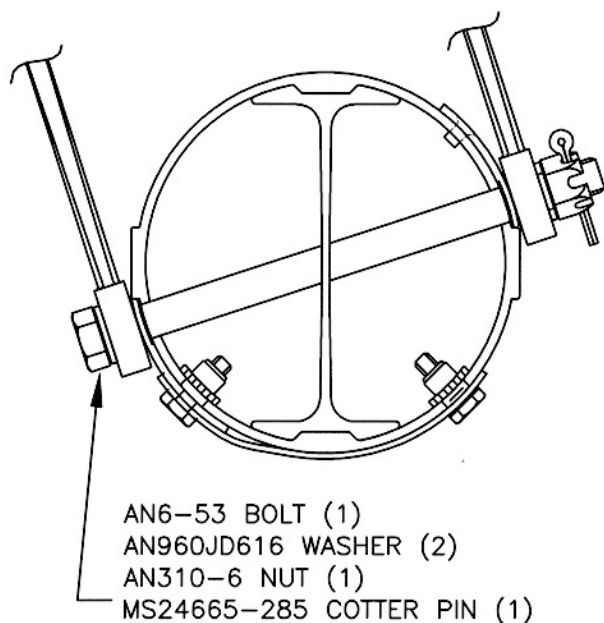
DESIGN	DRAWN BY <i>up</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. DSI 9262	REV. A SHEET 1 OF 1
DATE 03.05.14		TITLE SKIDTUBE REPAIR	SCALE NTS
A	03.05.14	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND D412-673 Rev. A
AND D205-634 Rev. A OR Rev. B
REF. CANADIAN STC: SH96-88
REF. FAA STC: SR000563NY

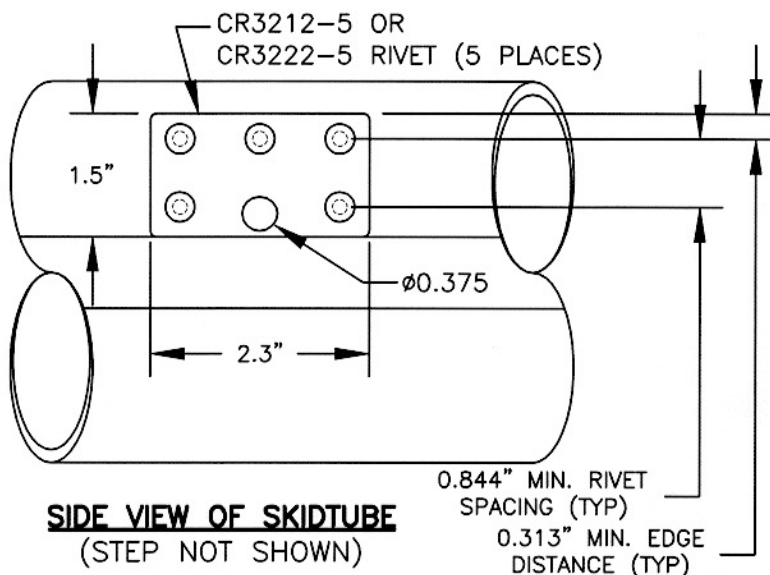
To repair elongated holes used to attach Bell electric step to Dart D205-634-011 skidtube:

- 1) Temporarily remove (4) bolts that attach electric step to Dart D205-634-011 skidtube.
- 2) Remove (4) ALS7-428-165 inserts.
- 3) Fabricate doublers from 1/4 hard 14 gauge (0.080") AISI 301/302/304/316 stainless steel per MIL-S-5059 as shown below.
- 4) Install over damaged area using CR3212-5 / CR3222-5 rivets and Proseal 890. The location of the doubler (and $\varnothing 0.375$ hole) may have to be adjusted fwd/aft to allow for fitting under the skidtube wearplates.
- 5) Reinstall electric step using hardware shown below. Transfer drill $\varnothing 0.375$ through web.



AN6-53 BOLT (1)
AN960JD616 WASHER (2)
AN310-6 NUT (1)
MS24665-285 COTTER PIN (1)

FWD/AFT VIEW OF SKIDTUBE



SIDE VIEW OF SKIDTUBE
(STEP NOT SHOWN)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: _____
D. SHEPHERD (DE # 02)

DATE: 03.05.14
CERT. NO.: SH96-88
ISSUE NO.: 1-2

REFERENCE ONLY.

NEVER APPROVED.

CUSTOMER USED AN5 BOLTS IN
COMBINATION WITH D2570 BUSHINGS

#03.06.24

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